

Work Order ID 142934

Friday, March 11, 2016 3:15:11 PM

142934

Page 1

Item ID: D3327-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 4/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAR 14 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3327	Rev B

100 Large Fab 0.00

100

Large Fab Memo 0.03

Large Fab 1-Cut tubes as per Dwg D3327

2- WELD AS PER DWG

B127925

1 FF MAR 18 2016

MAR 21 2016

DA3
24
9-00

CC 16-3-22

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00

Quality Control

① 16-03-30 ①

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

① 16-03-30 ①



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:			QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation					Disposition					
										Completed By
										Lead hand / Supervisor Approval Verification
										QC / QA Coordinator Approval
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due				FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence						
OTHER :										

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	<i>M 134371.</i> Memo 1ST COAT: <u>8:30.</u> START TIME: <u>1400°</u> OVEN TEMPERATURE: <u>9:20.</u> FINISH TIME: <u>***** 2nd coat if necessary *****</u> 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<i>1</i>	<i>0</i>	<i>16-03-31</i>	<i>15 00</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>1 0 16/63/7</i>

DAS
15
0-00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid Assembly

Stop ***NS2***Start Date: 4/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: w/b

0.00

150

Packaging

Memo

0.00

Packaging

D350-721-043 / B142920 1 x of 200 16/03/31

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MUS APR 06 2016MUS APR 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Friday, March 11, 2016 3:15:11 PM

Page 1

Work Order ID: 142934

142934

Parent Item: D3327-041

D3327-041

Parent Item Name: Basket Lid Assembly

Start Date: 4/4/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	480.0000	14.5	15.26316			

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

FF MAR 18 2016

Location	Loc Qty	Loc Code
WA004	480	
123339	167	
m132313	313	

15.26316

D3328-1

Manufactured No

100 Each 7.0000 2

D3328-1

Basket Hinge

MAR 21 2016

DAS
24
9-30

Location	Loc Qty	Loc Code
WA004	7	
84317	7	

2

D3349-1

Manufactured No

100 Each 16.0000 2

D3349-1

Spacer Bushing

MAR 21 2016

DAS
24
9-30

Location	Loc Qty	Loc Code
WA004	16	
44401	6	
86874	10	

2

D3352-1

Manufactured No

100 Each 5.0000 1

D3352-1

Label Plate

1 MAR 21 2016

DAS
24
9-30

Location	Loc Qty	Loc Code
WA004	5	
133426	4	
41925	1	

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
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LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
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Past Expiry Date ☐	☐	Manufacturing Process								
Misidentified ☐	☐	Past Due								
			OTHER : ☐							

Picklist Print

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Work Order ID: 142934

142934

Parent Item: D3327-041

D3327-041

Parent Item Name: Basket Lid Assembly

Start Date: 4/4/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3367-1

Manufactured No

100

Each

9.0000

2

2

D3367-1

MAR 21 2016

Mounting Bracket

**DAS
24
9-30**

Location

Loc Qty

Loc Code

WA004

9

125194

3

132542

6

Friday, March 11, 2016 3:15:11 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

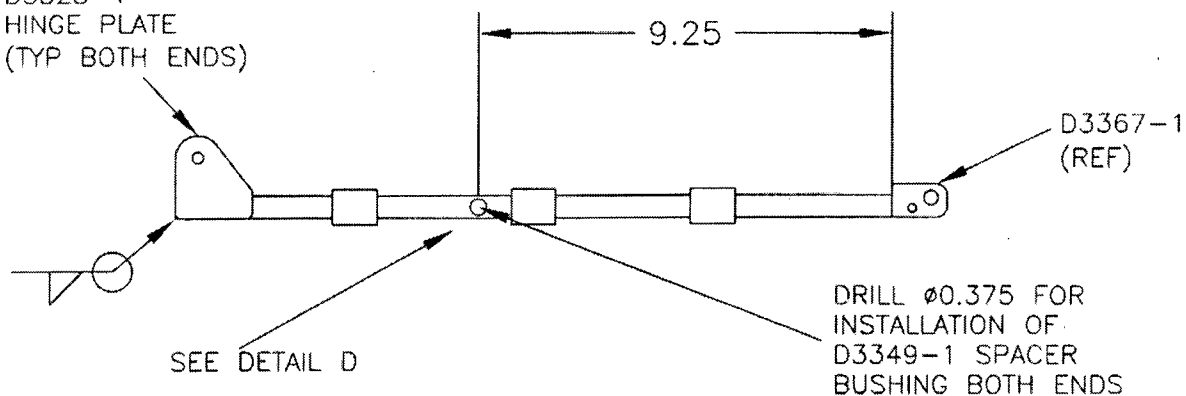
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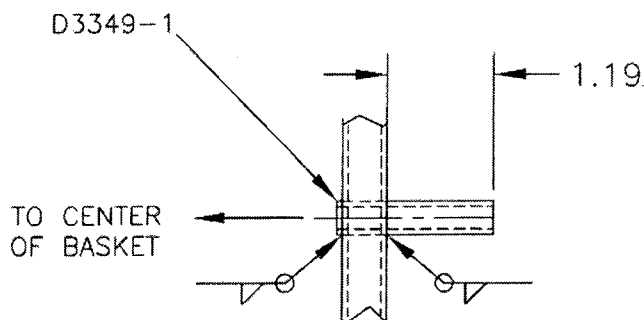


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3327	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A



DETAIL D
(SCALE 1:2)

DEO ATTACHED
RELEASED
05.04.28

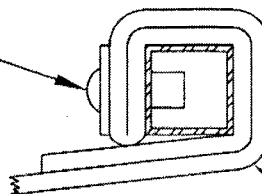
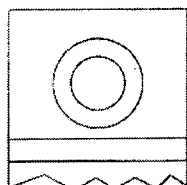
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DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3327	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



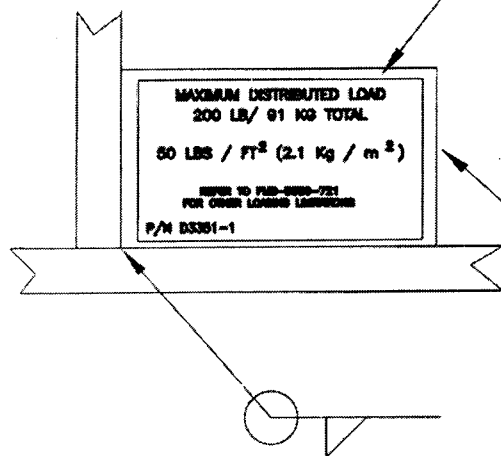
DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-043 WEBBING

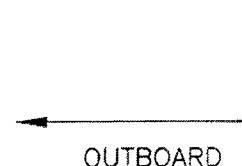
RELEASED
05.04.28 *[Signature]*

DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1



OUTBOARD

IDENTIFY WITH DART P/N
D350-721-043 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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DRAWING NO. D3327	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3327-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01			

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3327-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	24	RIVET

WAS:

MS20600AD4W3	24	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.